

Date: Tuesday, 29/07/2008 1:45:31 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40776
 Estimate Number : 13498
 P.O. Number :
 This Issue : 29/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run :
 Written By :
 Checked & Approved By : mf 08-07-29
 Comment : Est Rev:A 08-07-24 new issue DD verified by:ec

Drawing Name : OUTER TUBE
 Part Number : PB6743001205
 Drawing Number : B6743001 P.16
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 05/08/2008

Qty: 5 Um: Eac

Split

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T1750W065 6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 3.7958 f(s)/Unit Total: 18.9788 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M108551 = 3 M108659 = 2

08-01-29

2.0 BAND SAW BAND SAW



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2-cut a 27 degree angle on one end of tube as per dwg

2- deburr

08-07-29

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001

2- deburr

see last page
08-07-29

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-07-29

5.0 PB6743001199 Outer Tube End Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Outer Tube End Cap

batch: 40039 08-07-30

(3x)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER TUBE

Job Number: 40776

Part Number: PB6743001205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld end cap as per dwg PB67-43001
2-grind end cap flush

Handwritten: SP 08-07-30 (3x)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Handwritten: S 8/7/30 (+3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: S 8/7/30 (+3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *WA*

Handwritten: SP 08-07-31 (3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: D 08/05/08

Job Completion

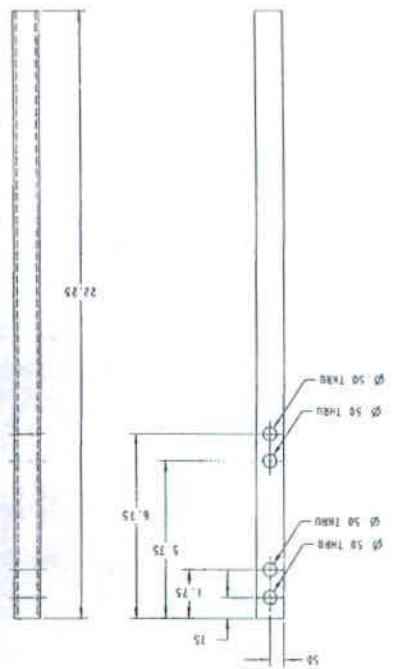


Handwritten: mf 08-08-01

ORIGINAL

PREMIER AVIATION, INC.
10000 Airport Freeway, Suite 2000
Dallas, Texas 75243
01050VR B67-43001

① -207 SQUARE TUBE
MATERIAL: 1.00 OD X .125 WALL, 6061-T6
SCALE: 0.500



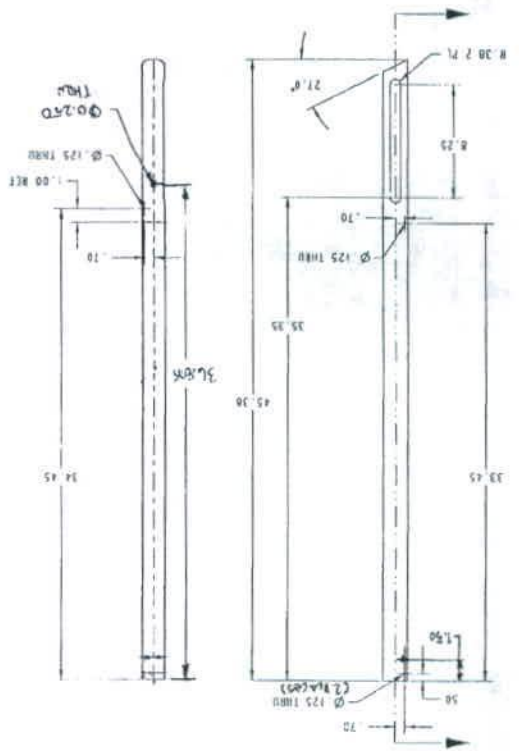
RELEASED
DEC 14 2000

⑤ -201 SQUARE TUBE
MATERIAL: 1.00 OD X .063 WALL, 6061-T6
SCALE: 0.500

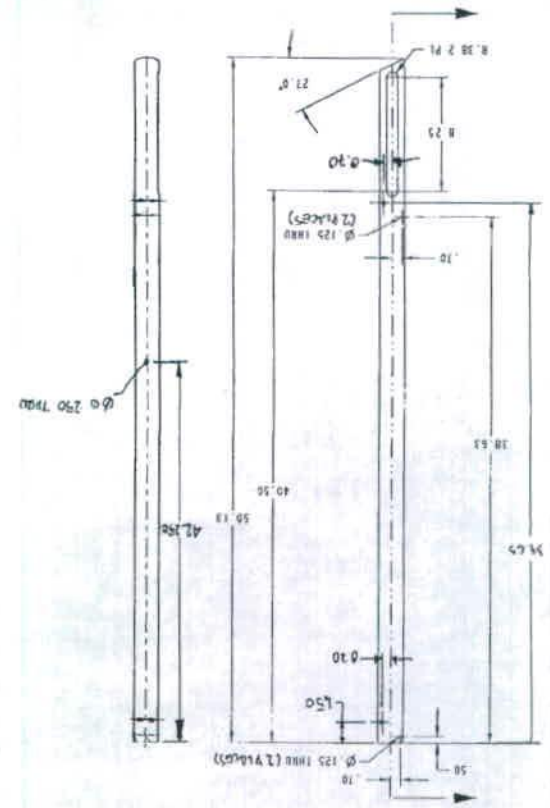


#40776

② -205 OUTER TUBE
MATERIAL: 1.75 OD X .063 WALL, 6061-T6
SCALE: 0.250



③ -197 OUTER TUBE
MATERIAL: 1.75 OD X .063 WALL, 6061-T6
SCALE: 0.250



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-205 PAR #: N/A Fault Category: Prod / FAB Large NCR ☒ Yes No DQA: ☒ QA: N/C Closed: ☒ Date: 08/05/08
 Date: 08/05/08

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/07/09	# 20	operator the ^{cut} button angle on the wing operation to the holes R.C. operator error Human error	<i>[Signature]</i> 08/07/09	Scrap and Destroy the Replace with SC <i>[Signature]</i> to be replaced on split w/b 8/7/30	<i>[Signature]</i> 08-07-30	<i>[Signature]</i> 8/7/30	<i>[Signature]</i> 08/14/09	<i>[Signature]</i> 08/14/09

NOTE: Date & initial all entries

